

Work Order ID 159882

Wednesday, April 19, 2017 12:11:14 PM

U/R

OK of 12/5/13

159882

Page 1

Item ID: D3594-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: URF 16-673 Stop ***NS2***
 Item Name: Floor Doubler Assembly, LH
 Start Date: 4/22/2017 Start Qty: 400 ***4*** Cust Item ID:
 Required Date: 5/1/2017 Req'd Qty: 400 ***4*** Customer:
 Reference: SCHEDULED/S

Approvals: Process Plan: DAS 21 Date: APR 19 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3594	C/U/R Rev. D								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.21							
FLOW CNC Waterjet	1-Cut as per Dwg D3594								
	Dwg Rev: <u>D</u>								
	Prog Rev: <u>D</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.04							
Quality Control									

(10) 02/17/06/08

(10) 02/17/06/08

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Page 2

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

Work Order ID 159882***159882***

Page 4

Wednesday, April 19, 2017 12:11:14 PM

Item ID: D3594-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 16-673 Stop ***NS2***
Item Name: Floor Doubler Assembly, LH
Start Date: 4/22/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/1/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
180									
QC	Memo	0.08							
Quality Control									JUN 23 2017
190	Identify as per dwg & Stock Location <u>Stacy</u>	0.00							
190									
Packaging	Memo	0.04							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.40							
Quality Control									

DAS
21
9-89 JUN 26 2017

Picklist Print

Wednesday, April 19, 2017 12:11:14 PM

Page 1

Work Order ID: 159882

159882

Parent Item: D3594-043

D3594-043

Parent Item Name: Floor Doubler Assembly, LH

Start Date: 4/22/2017

Required Date: 5/1/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07-01-22 EC
16.07.28 DWG REV.C DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.080

Purchased

No

100

sf

176.6500

0.51
0.76

2.147368

M6061T6S 080

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT020

176.65

m135861

9.5

m136342

73.85

m136632

8.9

m137110

20.4

m137263

64

MS20426AD4-4

Purchased

No

170

Each

2,773.000

2

8

MS20426AD4-4

Rivet

Location

Loc Qty

Loc Code

GA

1278

125445

1278

ST312

1495

m132536

1495

MS21069L3

Purchased

No

140

Each

96.0000

1

4

MS21069L3

ANCHOR NUT

Location

Loc Qty

Loc Code

ST299

96

m136740

16

m136986

80

MS21069-5

per Rev. D.

U 17/5/10

DAS 03 17-6-8
** 0.51
0.76

OK 17/06/08

8.7

17/06/23

DAS 36 9-89

10

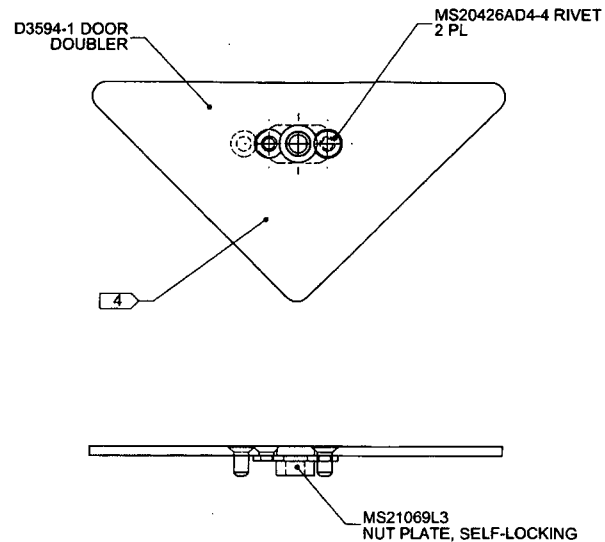
17/06/23

DAS 36 9-89

137587 (9X)

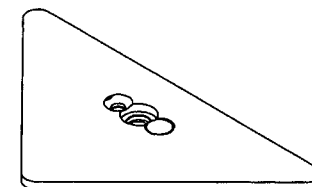
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ITEM	QTY	P/N	DESCRIPTION
	X	D3594-041	DOUBLER ASSEMBLY
1	1	D3594-1	DOUBLER
2	1	MS21069L3	NUT PLATE, SELF-LOCKING
3	2	MS20426AD4-4	RIVET, SOLID, CSK



D3594-041 DOOR DOUBLER ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 159882 *ML5*
1704-19



UNDER REVIEW

URF16-673 CP
16-11-16

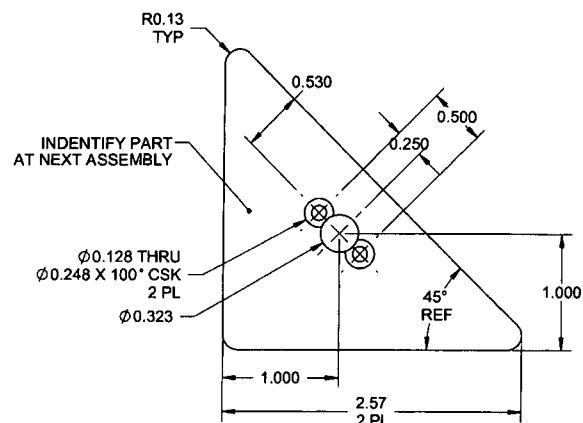
RELEASED
2016-07-26
ECN 16-531

C	REFORMAT TO CURRENT STANDARDS. ADD 0.5" OF MATERIAL TO -3 & -4 REASON PAR16-501.	AJS	16.05.25
B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	MB	DRAWING NO.	REV. C
MFG. APPR.	DD	D3594	SHEET 1 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	DOUBLER	NTS
DATE	16.05.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

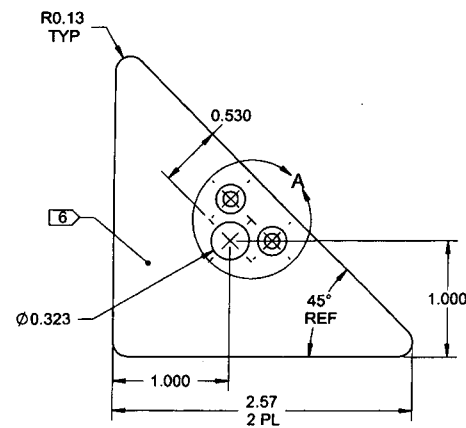
APPROVED

NOTES:

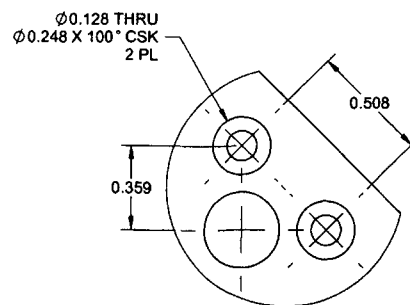
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 0.04 lbs



D3594-1 DOOR DOUBLER



D3594-5 DOOR DOUBLER



UNDER REVIEW

URF16-673 CP
16-11-16

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -5 ONLY: IDENTIFY PER DART QSI 044
- 7) WEIGHT -1/-5: 0.03 lbs

DETAIL A
SCALE 2X

RELEASED
2016-07-26

APPROVED

DESIGN	MB
DRAWN	AJS
CHECKED	MB
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	16.05.25

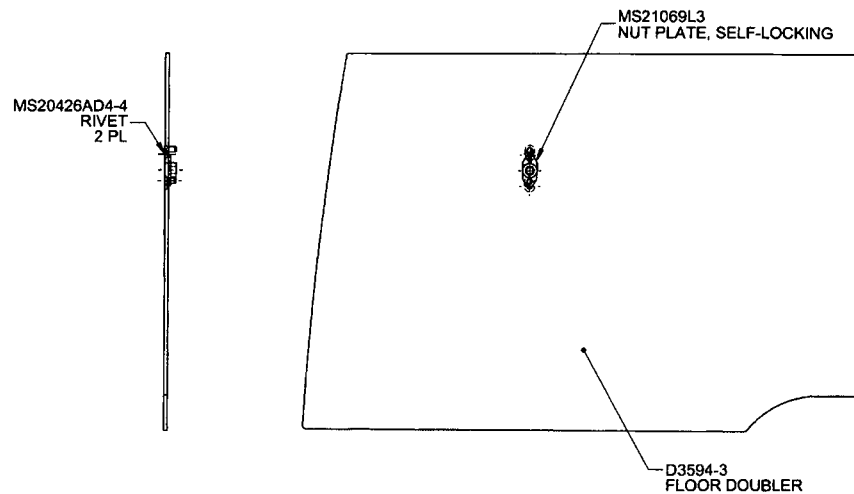
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV. C
D3594	SHEET 2 OF 4
TITLE	SCALE
DOUBLER	NTS

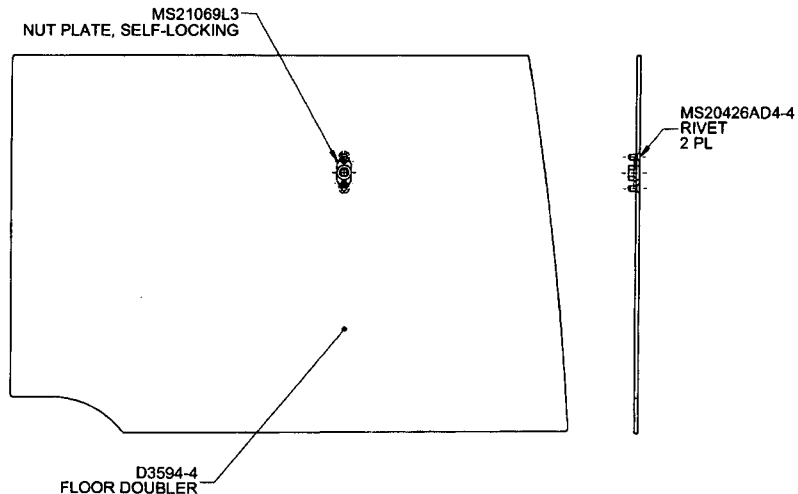
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ITEM	QTY	P/N	DESCRIPTION
	X	D3594-043	FLOOR DOUBLER ASSEMBLY
1	1	D3594-3	DOOR DOUBLER ASSEMBLY
2	2	MS20426AD4-4	RIVET, SOLID, CSK
3	1	MS21069L3	NUT PLATE, SELF-LOCKING

ITEM	QTY	P/N	DESCRIPTION
	X	D3594-044	FLOOR DOUBLER ASSEMBLY
1	1	D3594-4	DOOR DOUBLER ASSEMBLY
2	2	MS20426AD4-4	RIVET, SOLID, CSK
3	1	MS21069L3	NUT PLATE, SELF-LOCKING



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

UNDER REVIEW

URF16-673 CP
16-11-16

NOTES:
 1) MATERIAL: NONE
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 7) WEIGHT: 0.82 lbs

RELEASED
 2016-07-26

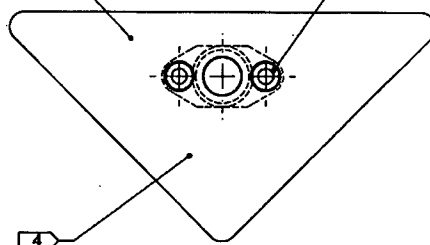
APPROVED

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. C
MFG. APPR.	DD	D3594	SHEET 3 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	D9	DOUBLER	NTS
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3594-041	DOUBLER ASSEMBLY
1	1	D3594-1	DOUBLER
2	1	MS21069-5	NUT PLATE, SELF-LOCKING
3	2	MS20426AD4-4	RIVET, SOLID, CSK

D3594-1 DOOR
DOUBLER

MS20426AD4-4 RIVET
2 PL



MS21069-5
NUT PLATE, SELF-LOCKING

D3594-041 DOOR DOUBLER ASSEMBLY

NOTES:

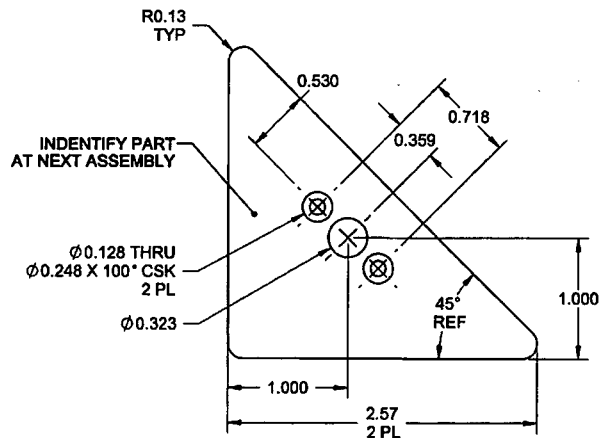
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 0.04 lbs

RELEASED

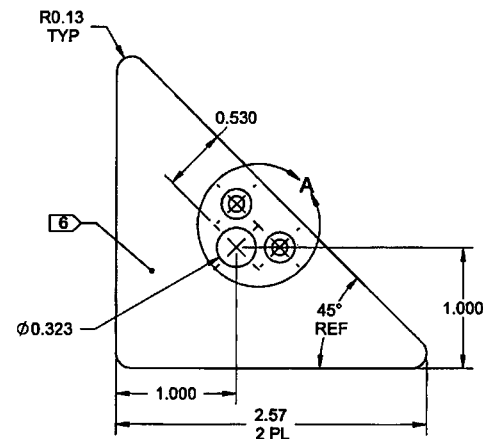
2017 APR 27
EJN 16-673

D	MS20169-5 WAS MS21068L3 (ZN D6-1, B3-1, D6-3, D3-3, C5-3, C4-3). REF PAR10-557	VS	17.04.07
C	REFORMAT TO CURRENT STANDARDS. ADD 0.5" OF MATERIAL TO -3 & -4 REASON PAR10-501.	AJS	18.05.25
B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. D
MFG. APPR.	DD	D3594	SHEET 1 OF 4
APPROVED	DSW	TITLE	SCALE
DE APPR.	N/A	DOUBLER	NTS
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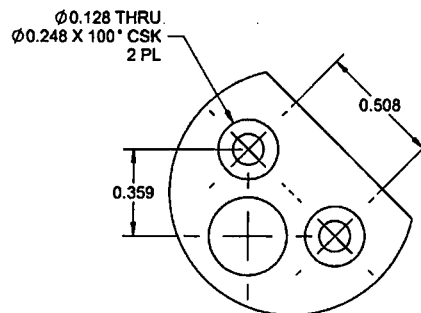
APPROVED



D3594-1 DOOR DOUBLER



D3594-5 DOOR DOUBLER



**DETAIL A
SCALE 2X**

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF. DART SPEC. M6061T6S.080
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION -5 ONLY: IDENTIFY PER DART QSI 044
 - 7) WEIGHT -1/-5: 0.03 lbs

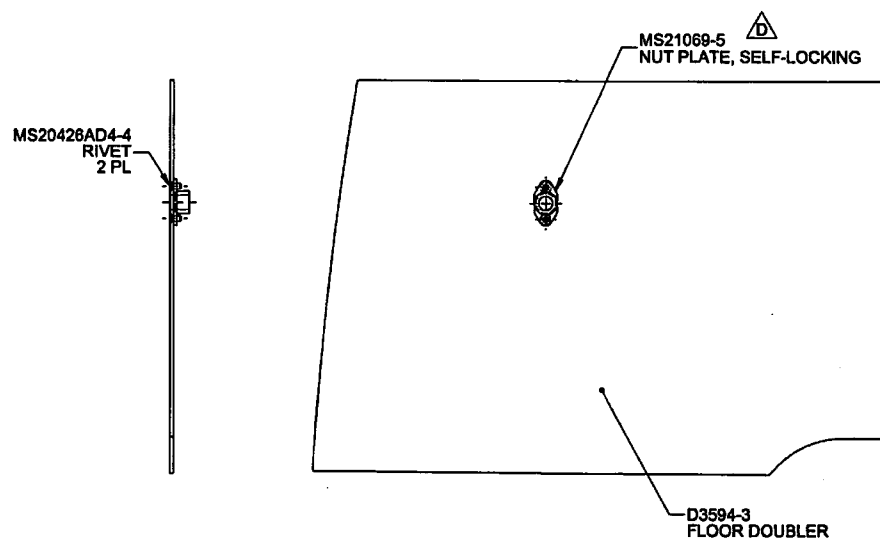
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2017 APR 27

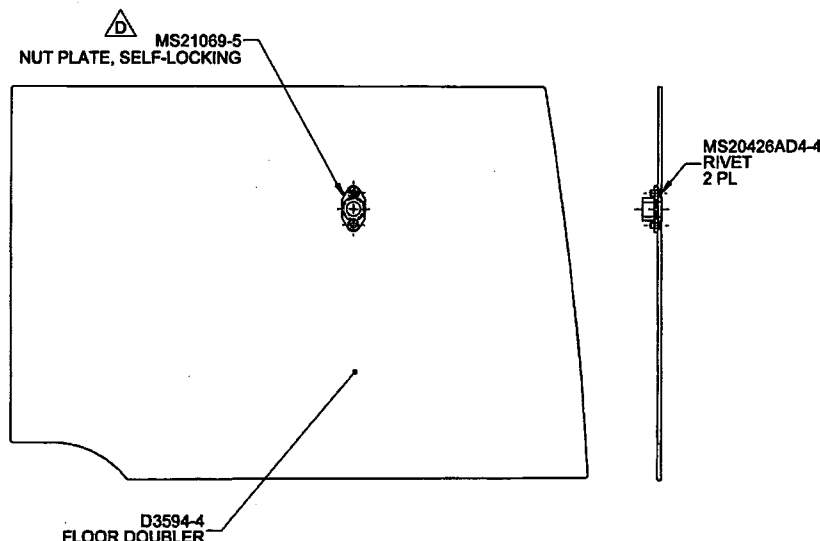
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. D
MFG. APPR.	DD	D3594	SHEET 2 OF 4
APPROVED	DSW	TITLE	SCALE
DE APPR.	N/A	DOUBLER	NTS
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ITEM	QTY -043	P/N	DESCRIPTION
	X	D3594-043	FLOOR DOUBLER ASSEMBLY
1	1	D3594-3	DOOR DOUBLER ASSEMBLY
2	2	MS20426AD4-4	RIVET, SOLID, CSK
3	1	MS21069-5	NUT PLATE, SELF-LOCKING

ITEM	QTY -044	P/N	DESCRIPTION
	X	D3594-044	FLOOR DOUBLER ASSEMBLY
1	1	D3594-4	DOOR DOUBLER ASSEMBLY
2	2	MS20426AD4-4	RIVET, SOLID, CSK
3	1	MS21069-5	NUT PLATE, SELF-LOCKING



D3594-043 FLOOR DOUBLER ASSEMBLY



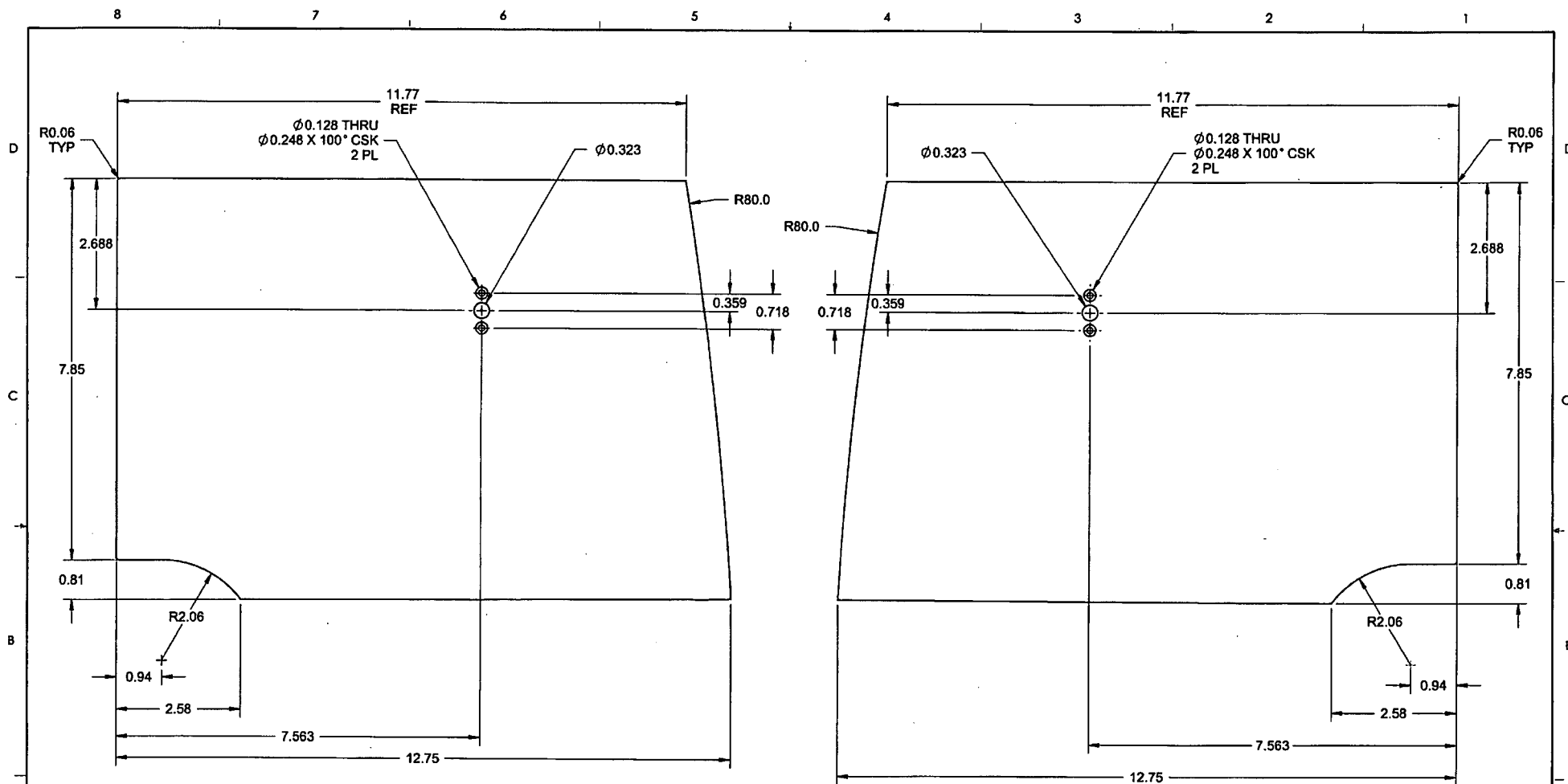
D3594-044 FLOOR DOUBLER ASSEMBLY

NOTES:
 1) MATERIAL: NONE
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 7) WEIGHT: 0.82 lbs

RELEASED
 2017 APR 27 *up*

APPROVED

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. D
MFG. APPR.	DD	D3594	SHEET 3 OF 4
APPROVED	DSW	TITLE	SCALE
DE APPR.	N/A <i>up</i>	DOUBLER	NTS
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D3594-3 FLOOR DOUBLER

D3594-4 FLOOR DOUBLER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: 0.82 lbs

RELEASED

2017 APR 27

APPROVED

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. D
MFG. APPR.	DD	D3594	SHEET 4 OF 4
APPROVED	DSW	TITLE	SCALE
DE APPR.	N/A WJ	DOUBLER	NTS
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